



Dart Aerospace Ltd.
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D5068-041
Job Sheet 186819



Part No: D5068-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, LH/RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5068 REV.A IPP REV:A 17.08.30 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Large Fab-7		CC
110	Large Fab	1 pcs		12/7/18	0.00	20.00	Large Fab 1		CC
120	QC	1 pcs		12/7/18	0.00	0.00	QC9		CC
130	QC	1 pcs		12/7/18	0.00	0.00	QC5		CC
140	HandFinish	1 pcs		12/7/18	0.00	0.25	HandFinish2		DR 19/01/09
150	Powdercoat	1 pcs		12/7/18	0.00	0.50	Powdercoat2		DR 19-01-09
160	QC	1 pcs		12/7/18	0.00	0.00	QC3		DR 19-01-09
170	HandFinish	1 pcs		12/7/18	0.00	0.25	HandFinish4		BEB 19-01-09
180	QC	1 pcs		12/7/18	0.00	0.00	QC5		JAN 09 2019 68
190	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3-2		BEB 19-01-09
200	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		21 JAN 09 2019

Part Op 110 - 1- Assemble ribs , weld as per dwg D5068 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D5068 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- Weld hinge (3) and Mounting brackets as per dwg D5068 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
150 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2-Mask this area prior to finish section A-A,
B-B 3-1ST COAT: START TIME: 11:00 OVEN TEMPERATURE: 375 FINISH TIME: 12:05
***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN
TEMPERATURE: _____ FINISH TIME: _____
170 - ASSEMBLE BLANKING PLATE AND BUMPER AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	100-Start up Operation	5125289
D3913-1	Rib	1 Ea (1 ea)	100-Start up Operation	5138226
D3913-15	Wide Handle Plate	1 Ea (1 ea)	100-Start up Operation	5115269
D3913-3	Rib	1 Ea (1 ea)	100-Start up Operation	5139345
D3913-9	Hinge Rib	1 Ea (1 ea)	100-Start up Operation	5133177
D3916-041	Rib Assembly	2 Ea (2 ea)	100-Start up Operation	5138851
D3916-5	Light Rib	2 Ea (2 ea)	100-Start up Operation	5115269
D4016-1	Hinge Half, Base	3 Ea (3 ea)	100-Start up Operation	5115309
D4017-7	Rib	3 Ea (3 ea)	100-Start up Operation	5123991
D4020-11	End Mesh, Basket	2 Ea (2 ea)	100-Start up Operation	5133427
D4021-1	Handle Plate	3 Ea (3 ea)	100-Start up Operation	5120559

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	100-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	100-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea) ✓	100-Start up Operation
D4785-117	Rib Assembly	2 Ea (2 ea)	100-Start up Operation
D5068-1	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-3	Rib	2 Ea (2 ea)	100-Start up Operation
D5068-5	Rib	1 Ea (1 ea)	100-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	170-HandFinish
D2931	Bumper	2 pcs (2 ea)	170-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	170-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	170-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	170-HandFinish
NAS1149DN832J	Washer	2 Ea (2 ea)	170-HandFinish

5138258
 5138521
 5126705
 5109214
 1x 504183/50424291x
 5034314
 5043106
 5034063
 5106952.
 F86435
 5118039.
 5076007
 5094592.
 5133206-1
 5131200

M.11007402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	D2581	2	58	0
	D3913-1	1	8	0
	D3913-15	1	12	0
	D3913-3	1	8	0
	D3913-9	1	5	0
	D3916-041	2	8	0
	D3916-5	2	9	0
	D4016-1	3	196	0
	D4017-7	3	38	0
	D4020-11	2	13	0
	D4021-1	3	36	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	24	0
	D4785-117	2	2	0
	D5068-1	2	4	0
	D5068-3	2	2	0
	D5068-5	1	2	0
	M304EX0.75-16F	33	2,292	0
170-HandFinish	AN3-10A	6	144	0
	D2931	2	910	0
	D4021-5	2	23	0
	MS20600-AD4W3	2	301	0
	MS21042L3	6	1,582	0
	NAS1149DN832J	2	554	0
	NAS1149F0332P	12	853	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
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		OTHER : _____																			

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Container No: S141539

Part: D5068 - 041

Job No: 186819

Serial No/Batch: S141539

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/03/19